

Work Order ID 70303

Thursday, June 02, 2011 2:37:14 PM

Page 1

Item ID: D3208-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 6/8/2011 Start Qty: 10.00

Required Date: 6/17/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 4.038" X 5.340" grain along 4.038" Identify for D3208-1

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and Fillet D3208-1 corner as per Dwg D3208 Identify as D3208-1

120

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-1 Form D3208-1 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208

ES 11/06/10 (10)

ES 11/06/13 (10)

SB 11/06/13 (10)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 06 13 (10)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10Xφ M-11/06/13

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10φ BK 11-6-13

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Required Date: 6/17/2011 Req'd Qty: 10.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 222

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/4/14 (10)

11/6/15 JF
MF
11-06-14

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 2:37:12 PM

Work Order ID: 70303

Parent Item: D3208-1

Parent Item Name: Doubler



Page 1

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B 04.05.25 Material changed for Step 4: KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

Purchased

No

100

sf

229.4000

0.1645

1.731579



2024-T3 .040 sheet



JS 11/06/10

Location

MAT022

112291

112331

113162

117684

Loc Qty

229.4

0.5

0.7

36.2

192

Loc Code

~~1.731579~~
1.731579

~~703~~

W/O:		WORK ORDER CHANGES						
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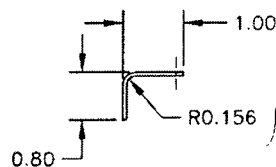
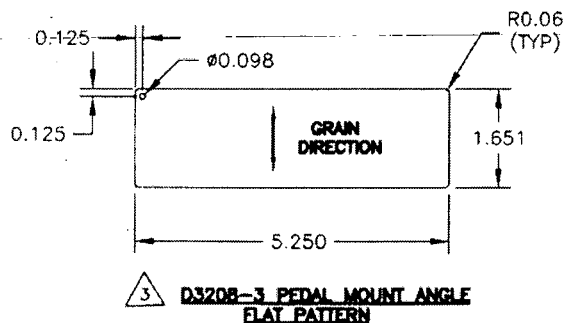
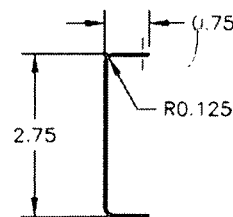
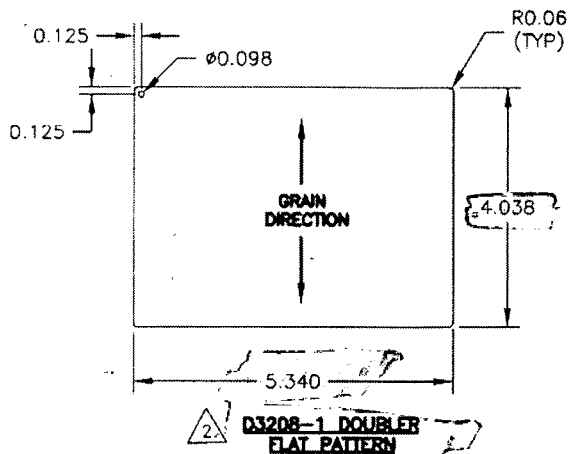
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DESIGN KT	DRAWN BY KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KT	APPROVED KT	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

RELEASED
RECEIVED



NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

W/670303

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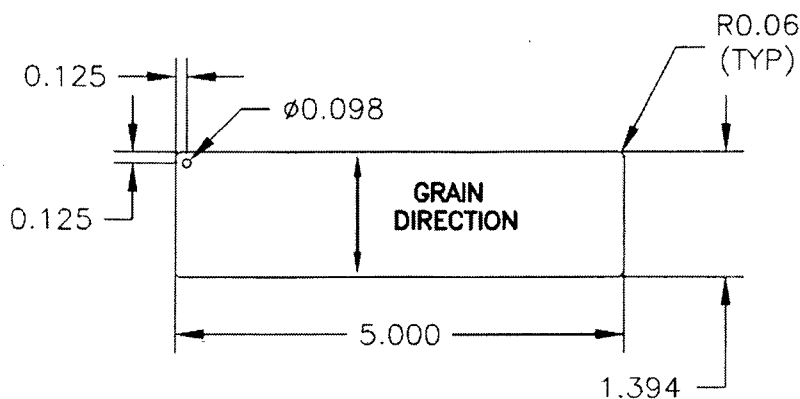
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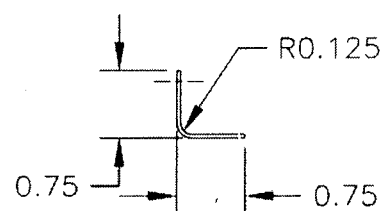


DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE DOUBLER		SCALE 1:2

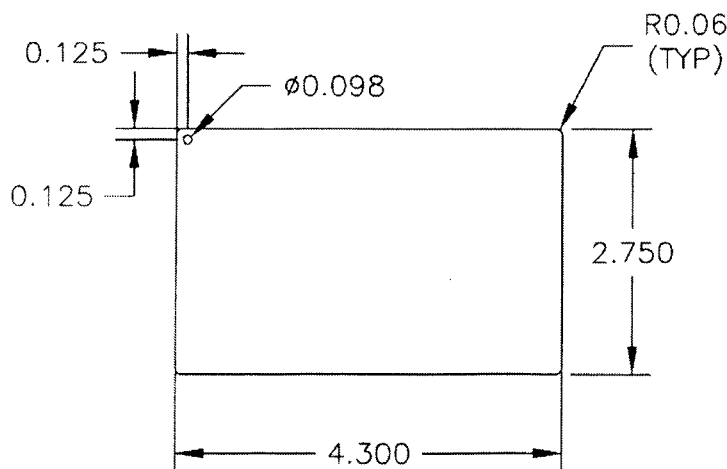
RELEASED
04.04.05 JH



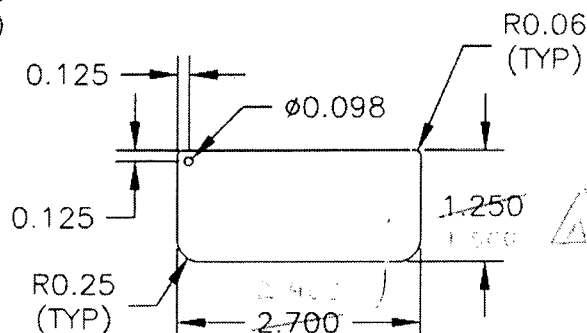
**D3208-5 MOUNT ANGLE
FLAT PATTERN**



**D3208-5 MOUNT ANGLE
BEND DETAIL**



D3208-7 FILLER



D3208-11 FILLER

20303

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Dart Aerospace Ltd

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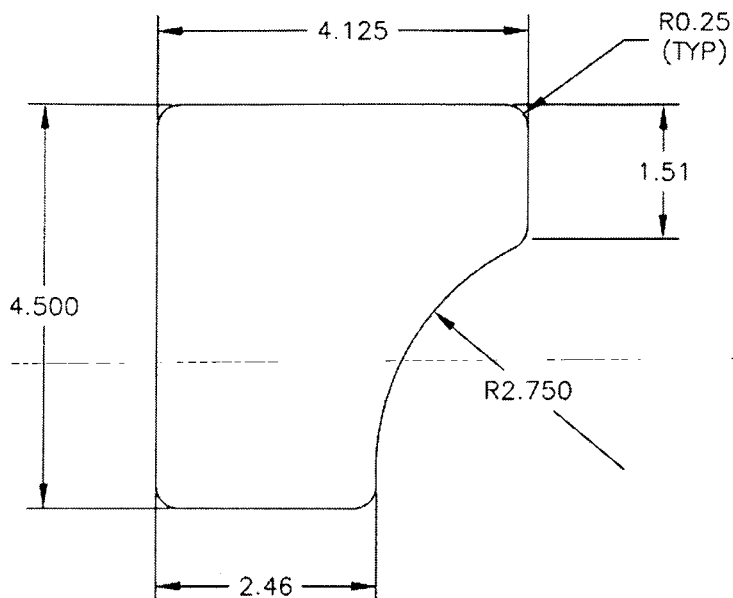
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DESIGN RT	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
04.01.05



D3208-9 DOUBLER

70303

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